

Date: Monday, 02/03/2009 9:04:07 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP WELDMENT
 Job Number : 46123
 Estimate Number : 10777
 P.O. Number :
 This Issue : 02/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 44480
 Written By :
 Checked & Approved By : JUD 09.03.02
 Comment : EST REV. A 05.11.18 new issue EC

Part Number : D3463042
 Drawing Number : D3463 REV.B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 16/03/2009 Qty: 8 Um: EACH

2 WF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

238806

SS DOWEL PIN 1" LONG



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

238-806

SS DOWEL PIN 1" LONG

M105037

EL 9-3-23 x12

2.0

D34533

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3453-3

Clevis

M46150

EL 9-3-23 x6

3.0

D34637

Drag Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3463-7

Drag Arm

B46271

EL 9-3-23 x6

4.0

D34631

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3463-1

Arm

B46148

EL 9-3-23 x6

Date: Monday, 02/03/2009 9:04:08 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 46123

Part Number: D3463042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34633

Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3463-3

Step

4x B44605

1 x B4606

1 x B44482

EL 9-3-23 x6

6.0

D34635

End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3463-5

Step Flat Pattern

B46270

EL 9-3-23 x12

7.0

D34535

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3453-5

Plug

1 x B39463

5 x B46151

EL 9-3-23 x6

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3463 using DT8875

EL 9-3-23 x2

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09.03.24

x2

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/03/24 x2-RH

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Mask areas indicated on dwg D3463 (holes, threads)

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

13:25

UMD/FL

x2

09/03/24

Date: Monday, 02/03/2009 9:04:08 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 46123

Part Number: D3463042

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 400°

FINISH TIME: 13:55

Umo/FL

09/03/24

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3463 and QSI 005 4.4

M109883

BL09-03-25

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-25

X2

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6-A

09/03/25

(2)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/25

Comment: FINAL INSPECTION/W/O RELEASE

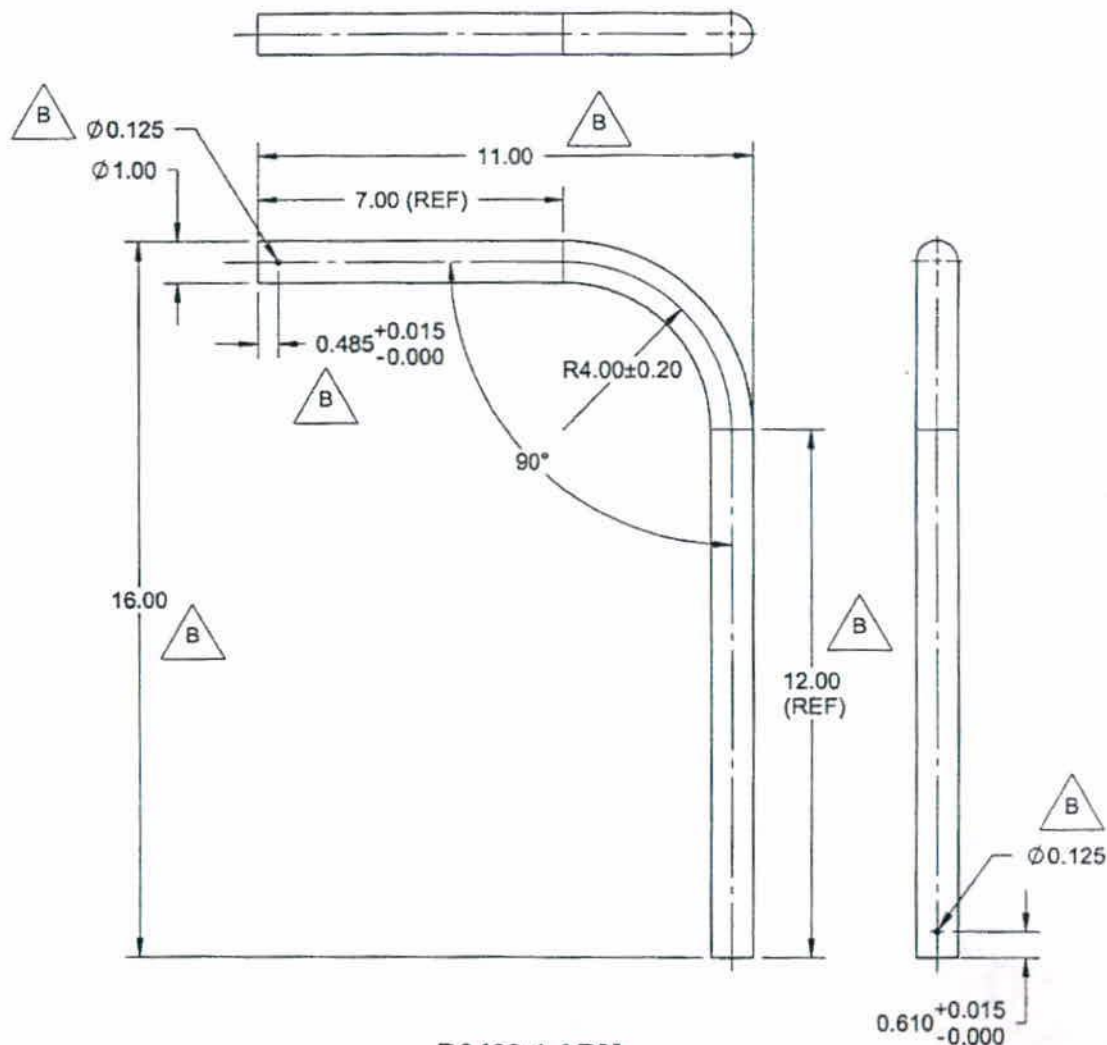

Job Completion



U 09/03-25

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED05.12.09 **D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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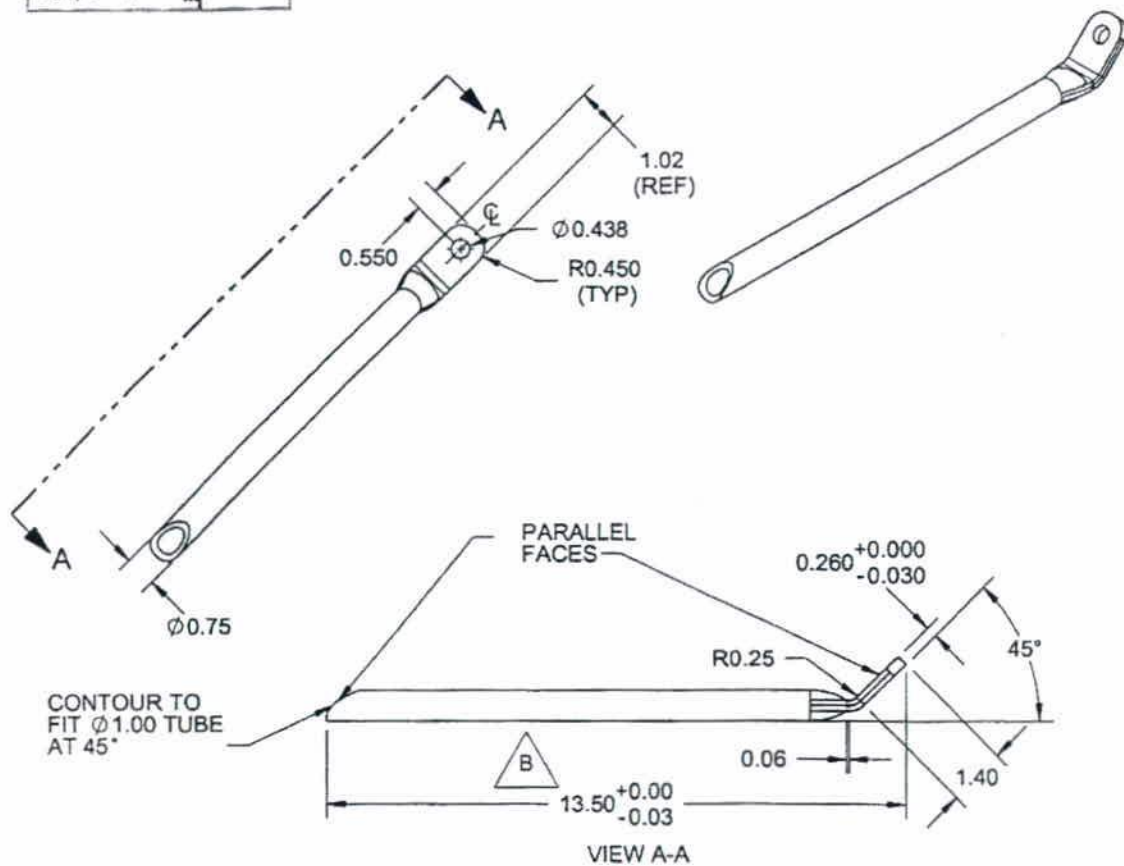
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CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.05

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750-120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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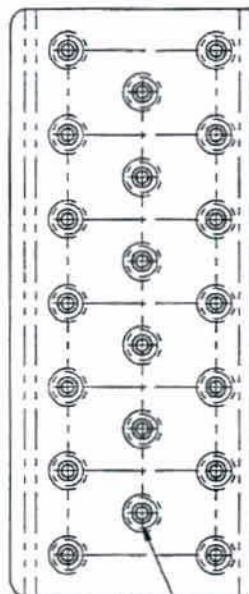
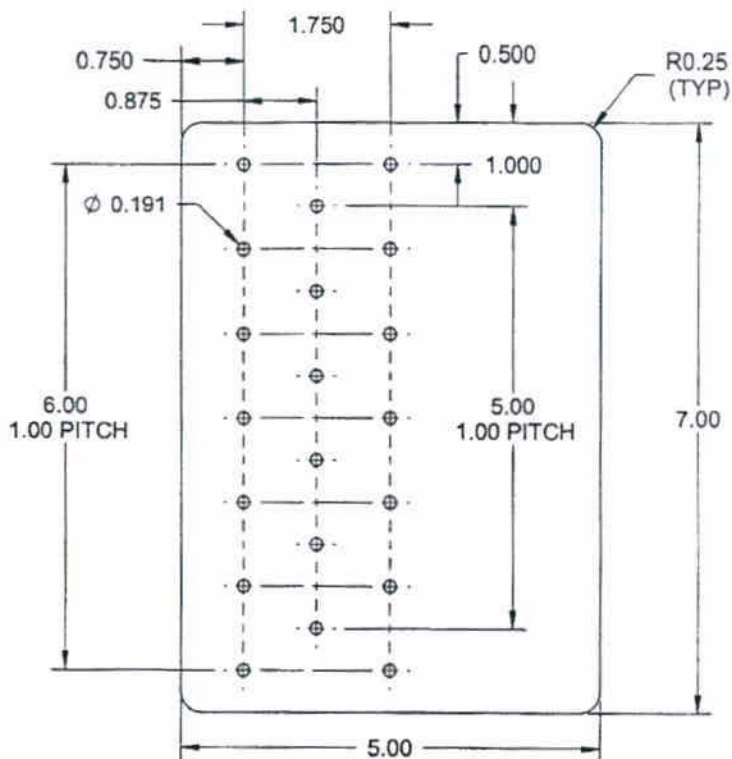
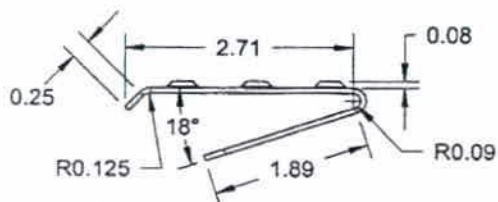
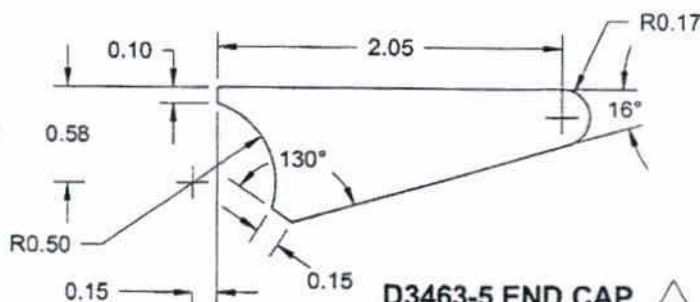
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED A	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

05.12.05 #

**FORM USING
D3463-3T1****D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**

SCALE 1:1

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S100A)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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